: BUSHING

: D2652

: 1/15/2007

: N/A

D2652 REV A

Wednesday, 12/20/2006 11:59:16 AM

Date: -User

Kim Johnston

**Process Sheet** 

**Drawing Name** 

Part Number

Material

Due Date

**Drawing Number** 

Project Number

**Drawing Revision** 

Customer

: CU-DAR001 Dart Helicopters Services

Job Number **Estimate Number**  : 29996

: 10725

P.O. Number

· NIA

This Issue Prsht Rev.

First Issue

Written By

**Previous Run** 

: 12/20/2006

: 29332

: NIA

S.O. No. : 12/11×

Type

: MACHINED PARTS

Checked & Approved By

Comment

: Est Rev:B

Now machined in house.

NG

Qty:

300 Um:

& F06/12/2

Each

**Additional Product** 

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M303R0500

303 Round Bar 0.500"

Comment: Qty.:

0.0578 f(s)/Unit Total: 17.3250 f(s)

Material:303 ss .500" Round Bar

(M303R0500)

Batch: M/09447

20

HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA250 & Dwg D2652

2-Deburr

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

PACKAGING 1

PACKAGING RESOURCE #1



5.0



Comment: PACKAGING RESOURCE #1

Identify and Stock Location: 454



Page 1

Form: rprocess

## Dart Aerospace Ltd

	WORK ORDER CHANGES									
STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
					;					
	STEP	STEP PROCEDURE CHANGE	STEP PROCEDURE CHANGE By	STEP PROCEDURE CHANGE By Date	STEP PROCEDURE CHANGE By Date Qty	STEP PROCEDURE CHANGE  By Date Qty Chief Eng / Prod Mgr				

Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date: <u>07/01/08</u>
		·	QA: N/C Closed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
DATE		Description of NC	Corrective Action Section B			Verification	A	A		
	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspecto		
						1				
						*				
						•				

NOTE: Date & initial all entries

Dațe:

Wednesday, 12/20/2006 11:59:17 AM

User:

Kim Johnston

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 29996

Part Number: D2652

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



B 07/01/08

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



1 67-01-08

## Dart Aerospace Ltd

W/O:		WORK ORDER C	HANGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		DAP #: Foult Catogony	NCP: Voc	No DO	Λ.	Data	

QA: N/C Closed: \_\_\_\_ Date: \_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)										
		Description of NC		Corrective Action Section B		Verification	Annroyal	Approval				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector				
							i					
							,					

NOTE: Date & initial all entries

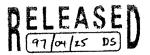
DART AEROSPACE LTD	Work Order:	29996
Description: Bushing	Part Number:	D2652
Inspection Dwg: D2652 Rev: A		Page 1 of 1

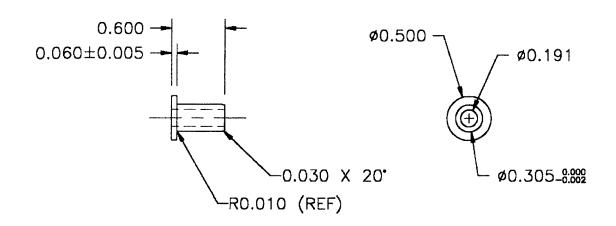
	FIRS	T ARTICLE I	NSPECTI	ON CHE	ECKLIST		
		X First Art	icle	Prot	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	С	omments
0.600	+/-0.010	.599	1				
0.060	+/-0.005	,058	ノ				
Ø0.305	-0.002/+0.000	, 304					
Ø0.191	+0.005/-0.000	-191					
Ø0.500	+/-0.010	,498	/				
0.030 x 20°	+/-0.010	,030x20°					
R0.010	+0.010/-0.000	,010	1				
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	1					ľ	
Measured by:	1) t <sup>&gt;</sup>	Audited by:	20		rototype Appr		N/A
Date: C	6/12/28	Date:	<u>06/19/29</u>	3   [		Date:	HIM.
Rev Date	Change				Re	vised b	Approved





	DESIGN	DRAWN BY	DART AEROSPACE US		Э.	
	CHECKED	APPROVED	DRAWING NO.	R	EV.	Ā
•	BW	01 BY	D2652	SHEET 1	OF	1
	DATE		TITLE		SCAL	E
	97:03:25		BUSHING		1	:1





SHOP COPY

RETURN TO
ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT
WITHOUT NOTICE

MATERIAL: AISI 303 SS

NOTE: BREAK ALL SHARP CORNERS 0.010 MAX

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED